

# POSTLE INDUSTRIES, INC.



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## Data Sheet

# POSTALLOY® 94

### Description

**POSTALLOY 94** is a bronze electrode that has the ability to join many types of base metals. Deposits are very tough and wear resistant, developing a tensile strength which will exceed most of the base metals it will be called upon to weld. Typical base metals are

Brass	Bronze	Tool steels
Brass to steel	Bronze to stainless	Cast iron
Copper to steel	Bronze to cast iron	Carbon steel
Copper to stainless		Stainless Steel

**Frictional Wear and Corrosion Resistance** - The corrosion resistance is among the best of the copper alloys, providing good resistance to salt water and acids. Deposits work-harden in service and take on an exceptionally high polish.

### Specifications

Tensile Strength.....	100,000 psi
Elongation .....	28%
Hardness as deposited.....	150 BHN
Work hardens to .....	225 BHN

### Applications

Bearings	Valve bodies and seats
Bushings	Guides
Impellers	Gear teeth and pulleys
Mixing arms	Non-sparking alloy
Paper mill rolls	Anit-scratch surface
Propellers	

### Welding Procedure - DC Reverse Polarity

Clean weld area. Vee out cracks with **POSTALLOY 250** gouging electrode. Heavy sections should be beveled. Preheat cast iron to about 400°F (204°C), heavy copper sections to about 1000°F (538°C), brass to about 600°F (315°C), and bronze to about 200°F (93°C). Strike and maintain a close arc. Hold electrode about 15° degrees off the perpendicular in direction of travel. Chip and brush off slag between passes. Allow part to cool.

Diameter	1/8 (3.2mm)
Current <i>amps</i>	80-130

Also available as a bare alloy for heliac -**TIGWELD 94-B** and semi-automatic GMA welding wire - **POSTALLOY 94-SPL**.